



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB 92700-10301-041-PO
Job Sheet 187974



Part No: RB 92700-10301-041-PO

Job Qty: 2 ea

Part Name: Pitch Beam Puller



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/28/18

Job Tracking No:

Due Date: 1/4/19

Created By: Chrisoula Tsimiklis

Type: Stock

Description:

Note: DWG RB 92700-10301-041 Rev.A IPP Rev. A 18.10.29 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs		1/4/19	0.00	0.00	Purchasing		JAN 17 2019
110	Packaging	2 pcs		1/4/19	0.00	0.00	Packaging2		JAN 17 2019
120	QC	2 pcs		1/4/19	0.00	0.00	QC6		38
130	Small Fab	2 pcs		1/4/19	0.00	0.20	Small Fab-2		9-89
140	QC	2 pcs		1/4/19	0.00	0.00	QC5		
150	Packaging	2 pcs		1/4/19	0.00	0.00	Packaging3		
160	QC21-FG	2 Ea		1/4/19	0.00	0.00	QC21		21 JAN 23 2019

Part Op 100 - Issue P/O: _____ MANUFACTURE RB 92700-10301-041 AS PER DWG Supplier: ARROW TECH MACHINE
Descriptions: WORKS -Certificate of conformity is required
130 - Re-identify as required.

GA150B

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB 92700-10301-041P	Pitch Beam Puller	2 Ea (1 ea)	100-Purchasing	S145801

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB 92700-10301-041P	2	0	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 12/28/18 2:04 PM dart.tsimiklis.chrisoula

Container No: S145804



Part: RB 92700-10301-041

Job No: 187974

Serial No/Batch: S145804

Revision: A

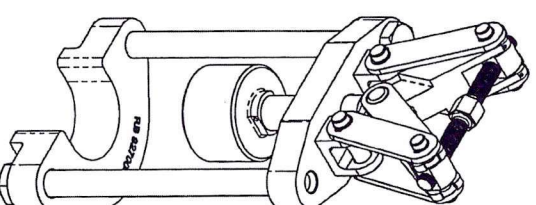
Inspector:

Exp Date:

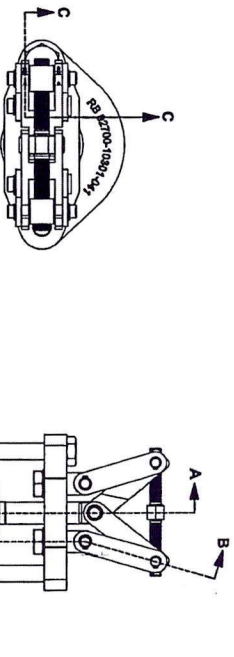
Instructions:

Date: 01/17/19

ITEM #	QTY	PART #	PART TITLE
-1	1	RB 92700-10301-041-1	PULLER PLATE
-2	2	RB 92700-10301-041-2	ROTATION PIN
-3	2	RB 92700-10301-041-3	BOLT
-4	1	RB 92700-10301-041-4	BASE
-5	1	RB 92700-10301-041-5	PUSHER ASSEMBLY
-6	1	RB 92700-10301-041-6	LINKAGE 1
-8	1	RB 92700-10301-041-8	LINKAGE 2
-9	1	RB 92700-10301-041-9	LINKAGE 3
-10	4	RB 92700-10301-041-10	LEFT HAND LINKAGE PIN
-11	1	RB 92700-10301-041-11	RIGHT HAND LINKAGE PIN
-12	1	RB 92700-10301-041-12	LINKAGE PIN
-13	2	RB 92700-10301-041-13	LINKAGE SCREW
-14	1	RB 92700-10301-041-14	STEEL WASHER 0.77" ID. X 1.25" OD.
-15	2	McMaster991922A312 OR EQUIV.	SS SPRING PIN 3/64" DIA. X 1" LG.
-16	2	McMaster92373A149 OR EQUIV.	STEEL THIN HEX NUT 3/4"-16 X 27/64" HEIGHT.
-17	2	McMaster93359A440 OR EQUIV.	SS DOWEL PIN 5/8" DIA. X 1-1/2" LG.
-18	1	McMaster97385A821 OR EQUIV.	STEEL EXTERNAL RETAINING RING FOR 7/16" OD.
-19	4	McMaster99410A119 OR EQUIV.	STEEL EXTERNAL RETAINING RING FOR 1/2" OD.
-20	2	McMaster99410A122 OR EQUIV.	STEEL EXTERNAL RETAINING RING FOR 1/2" OD.

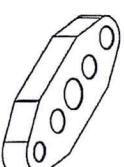


RB 92700-10301-041 PULLER ASSEMBLY

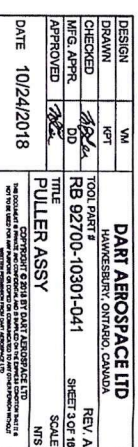


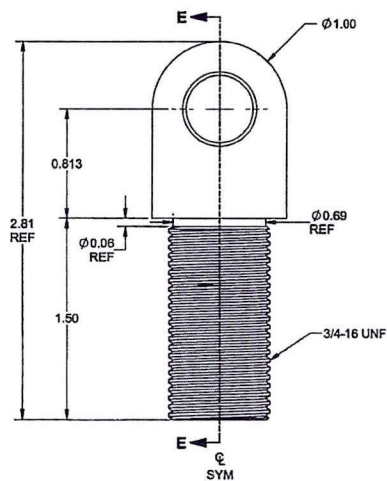
REV.	NEW ISSUE	DESCRIPTION	18-704	VM
DESIGN	WI	DART AEROSPACE LTD	ECN #	BY
DRAWN	JPT	HAWESBURY, ONTARIO CANADA		
CHECKED	<i>[Signature]</i>	TOOL PART #		REV/A
MFG APPR	DD	RB 92700-10301-041		SHEET 1 OF 18
APPROVED	<i>[Signature]</i>	PULLER ASSEMBLY		SCALE
DATE	10/24/2018			MKS

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" I +/- 1"
X.XX = +/- 0.01" I +/- 0.5"
X.XXX = +/- 0.005" I +/- 0.1"
X.XXXX = +/- 0.0005" I +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A

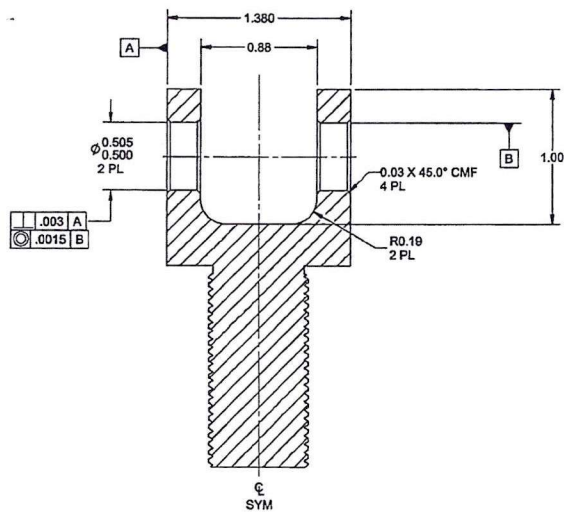


RB 92700-10301-041-1 PULLER PLATE





RB 92700-10301-041-2 ROTATION PIN

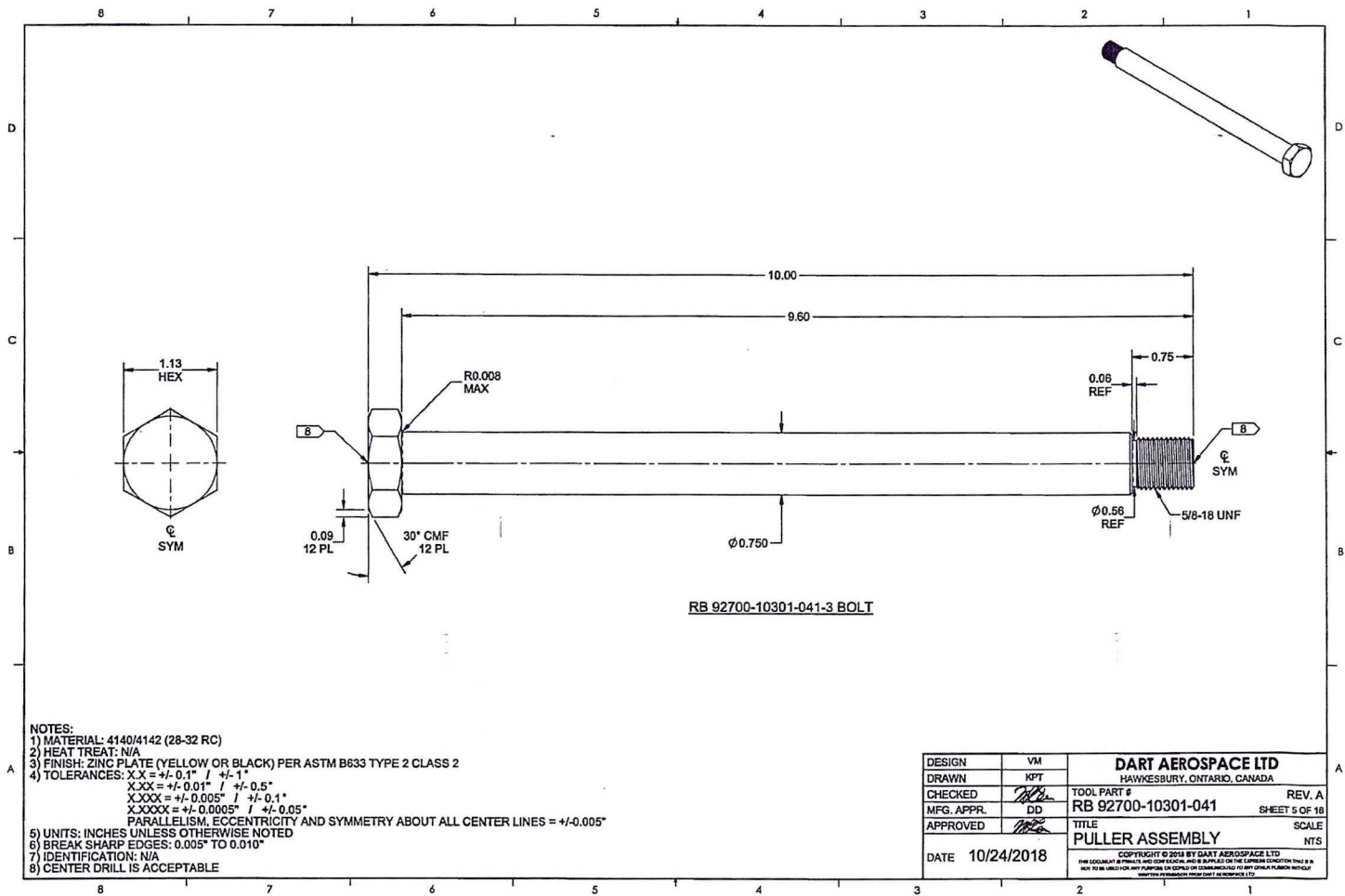


SECTION E-E

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: XX = ± 0.01 " / ± 0.5 "
 XXX = ± 0.005 " / ± 0.1 "
 XXXX = ± 0.0005 " / ± 0.05 "
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

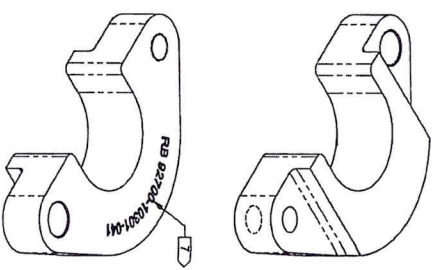
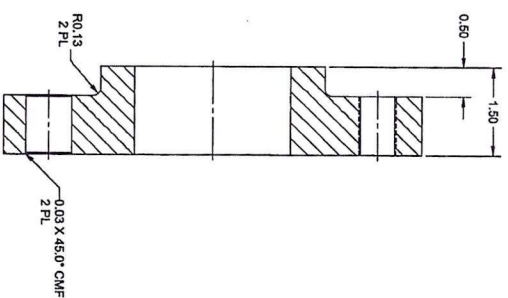
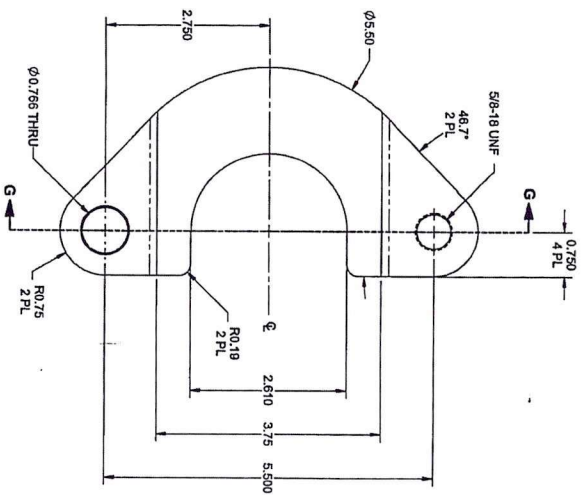
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DD	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 4 OF 16
APPROVED	DD	TITLE	SCALE
DATE 10/24/2018		PULLER ASSY	NTS
COPYRIGHT © 2018 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRELIMINARY. CONFIDENTIALITY IS IMPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.			



NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 0.1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 5 OF 18
APPROVED	<i>[Signature]</i>	TITLE	SCALE
		PULLER ASSEMBLY	NTS
DATE	10/24/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRELIMINARY AND FOR EXAMINATION ONLY. IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



RB 92700-10301-041-4 BASE

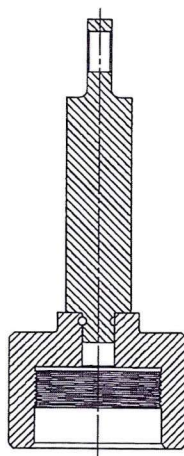
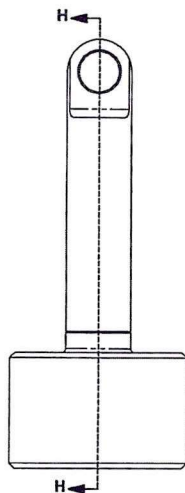
SECTION G-G

PART AEROSPACE LTD			
DESIGN	WM	TITLE	PULLER ASSEMBLY
DRAWN	WRT	TOOL PART #	RB 92700-10301-041
CHECKED	WRT	REV / A	
MFG. APPR.	DD	SHEET 1 OF 1	
APPROVED	WRT	SCALE	NIS
DATE	10/24/2018		

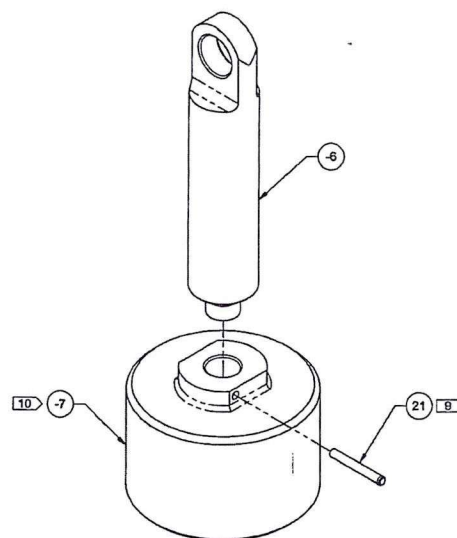
CONTRACTOR: GEMINI PART ASSEMBLY LTD.
1000 BAYVIEW AVENUE, SUITE 100, SCARBOROUGH, ONTARIO M1S 5B7
TEL: (416) 291-1111 FAX: (416) 291-1112

- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B693 TYPE 2 CLASS 2
 - 4) TOLERANCES:
XXX = ± 0.01 / $\pm 0.5^\circ$
XXXX = ± 0.005 / $\pm 0.1^\circ$
XXXXX = ± 0.0005 / $\pm 0.05^\circ$
 - 5) UNITS: INCHES UNLESS OTHERWISE SPECIFIED
 - 6) BREAK SHARP EDGES: 0.005 TO 0.010"
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK TYN RB 92700-10301-041* AS SHOWN

ITEM #	QTY	PART #	PART TITLE
-6	1	RB 92700-10301-041-6	PUSHER PIN
-7	1	RB 92700-10301-041-7	PUSHER BASE
21	1	McMaster#97395A452 OR EQUIV.	SS DOWEL PIN 1/8" DIA. X 1" LG.



SECTION H-H



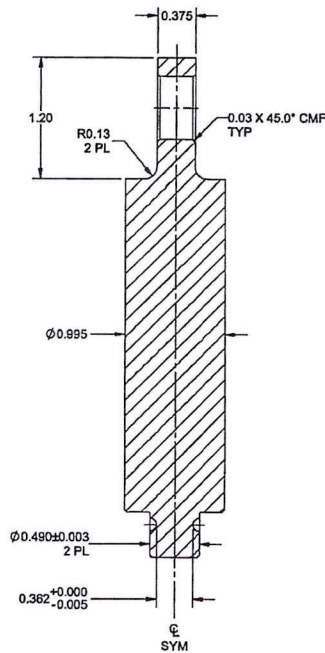
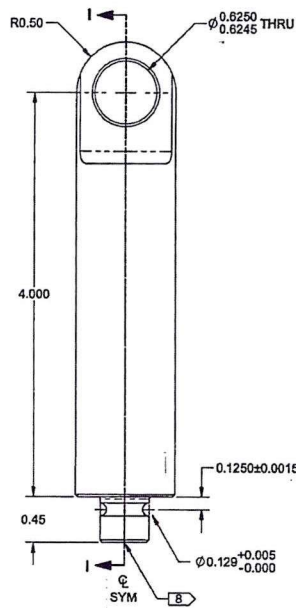
RB 92700-10301-041-5 PUSHER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN
- 9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 21 WITH ITEM -7 AND REMOVE EXCESS
- 10) ITEM -7 MUST ROTATE FREELY

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 7 OF 16
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	10/24/2018	PULLER ASSEMBLY	NTS

COPYRIGHT © 2018 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.

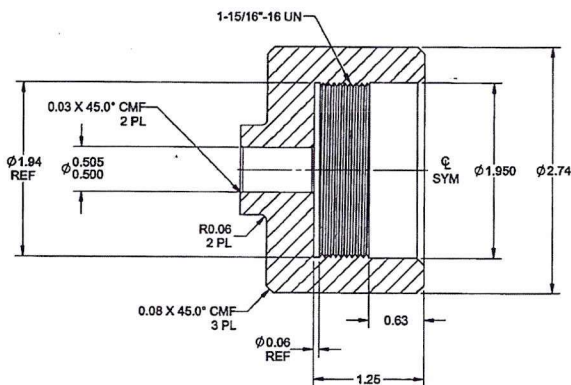
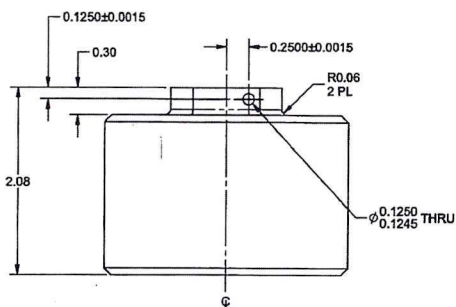
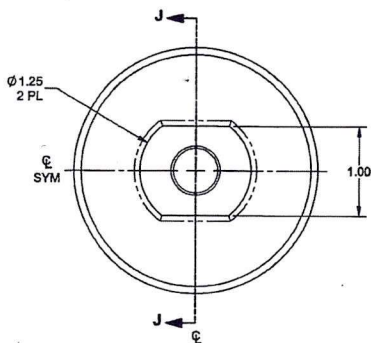


RB 92700-10301-041-6 PUSHER PIN

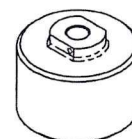
SECTION I-I

- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A
 - 8) CENTER DRILL IS ACCEPTABLE

DESIGN	YM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DD	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 8 OF 18
APPROVED	ML	TITLE	SCALE
DATE	10/24/2018	PULLER ASSEMBLY	NTS
COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS RELEASED AND CONFIDENTIALITY IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			



SECTION J-J



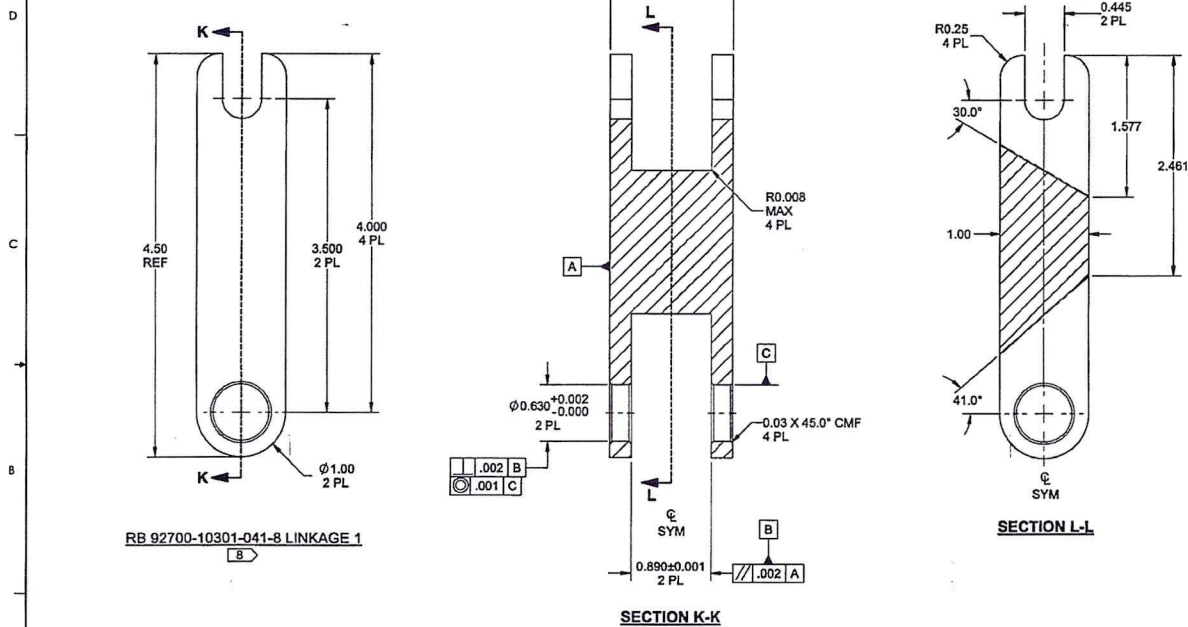
RB 92700-10301-041-7 PUSHER BASE

- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1/2/4 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: XX = ± 0.1 " / ± 1 "
XXX = ± 0.01 " / ± 0.5 "
XXXX = ± 0.005 " / ± 0.1 "
XXXXX = ± 0.0005 " / ± 0.05 "
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MM	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 9 OF 16
APPROVED	MM	TITLE	SCALE
DATE	10/24/2018	PULLER ASSEMBLY	NTS

COPYRIGHT © 2018 BY DART AEROSPACE LTD
THIS DOCUMENT IS UNCLASSIFIED AND NOT FOR DISTRIBUTION OUTSIDE THE COMPANY
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD

8 7 6 5 4 3 2 1



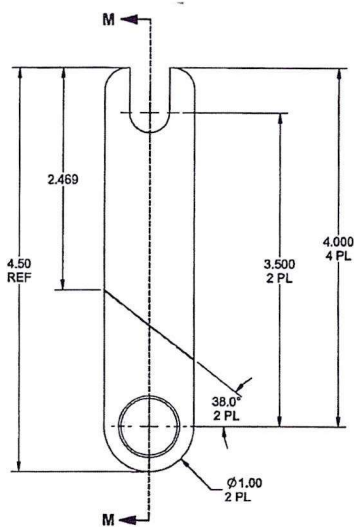
NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = $\pm 0.1^\circ$ / $\pm 1^\circ$
X.XX = $\pm 0.01^\circ$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005^\circ$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005^\circ$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005^\circ$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A
- 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF $\pm 0.005^\circ$ PER CAD FILE RB 92700-10301-041-8.STEP

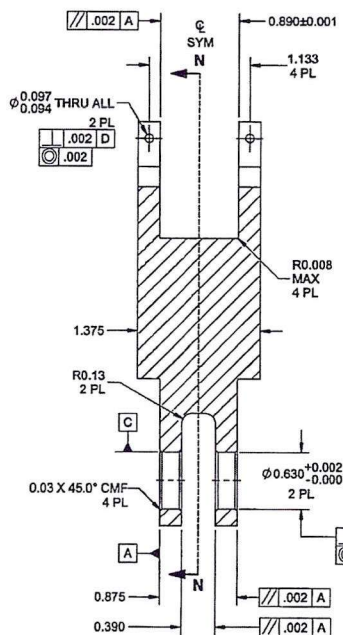
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>Mc</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 10 OF 18
APPROVED	<i>Mc</i>	TITLE	SCALE
DATE	10/24/2018	PULLER ASSEMBLY	NTS

COPYRIGHT © 2018 BY DART AEROSPACE LTD
THIS DOCUMENT IS UNCLASSIFIED, AND IS RELEASED ON THE EXPRESS CONDITION THAT IT BE
NOT BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
DART'S WRITTEN PERMISSION FOR THE DART OR DART/18/01/01

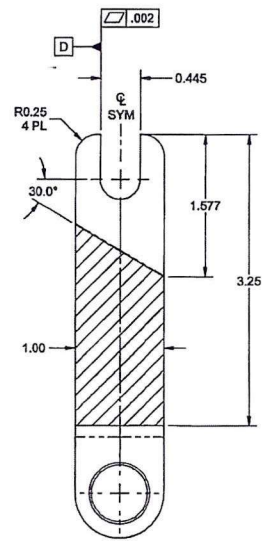
8 7 6 5 4 3 2 1



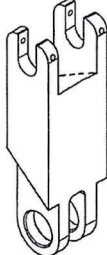
RB 92700-10301-041-9 LINKAGE 2



SECTION M-M

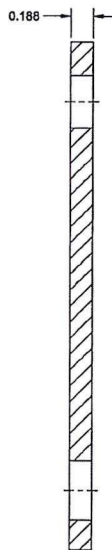
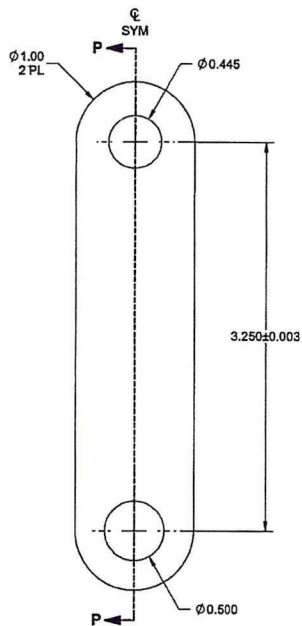


SECTION N-N

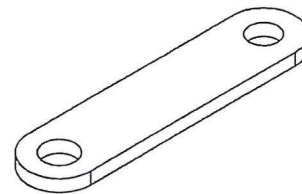


- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A
 - 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF $\pm 0.005"$ PER CAD FILE RB 92700-10301-041-9.STEP

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MS	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 11 OF 18
APPROVED	MS	TITLE	SCALE
		PULLER ASSEMBLY	NTS
DATE	10/24/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD	
		THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION P-P



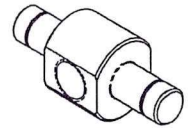
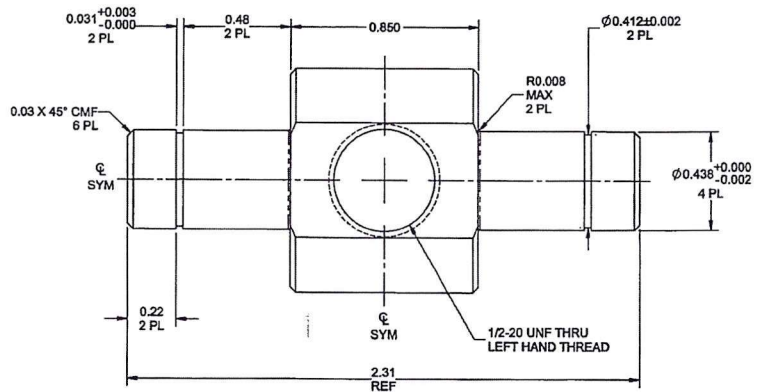
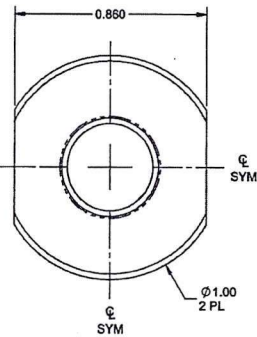
RB 92700-10301-041-10 LINKAGE 3

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: XX = $\pm 0.1"$ / $\pm 0.1"$
 XXX = $\pm 0.01"$ / $\pm 0.5"$
 XXXX = $\pm 0.005"$ / $\pm 0.1"$
 XXXXX = $\pm 0.0005"$ / $\pm 0.05"$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 12 OF 18
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE 10/24/2018		PULLER ASSEMBLY	NTS

COPYRIGHT © 2018 BY DART AEROSPACE LTD
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS
 NOT TO BE USED FOR ANY PURPOSES OR COPIES OR REPRODUCED TO ANY OTHER PERSON OR ENTITY
 WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD



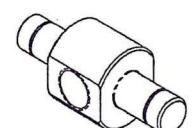
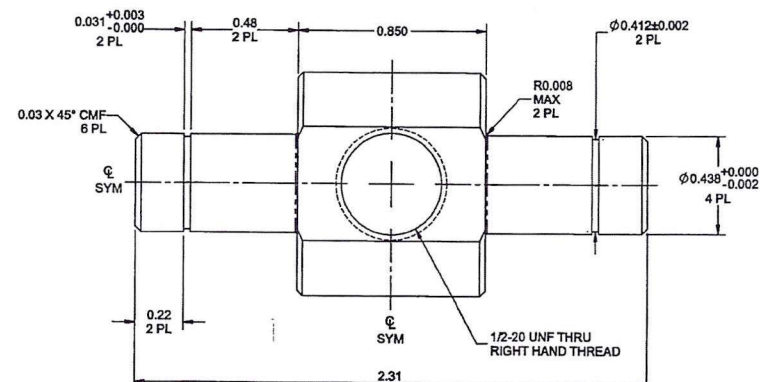
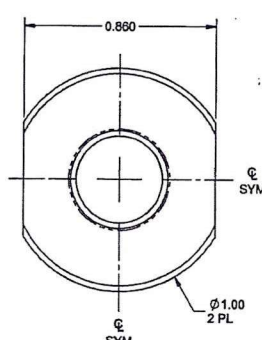
RB 92700-10301-041-11 LEFT HAND LINKAGE PIN

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: XX = ± 0.1 " / ± 1 "
 XXX = ± 0.01 " / ± 0.5 "
 XXXX = ± 0.005 " / ± 0.1 "
 XXXXX = ± 0.0005 " / ± 0.05 "
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 13 OF 18
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	10/24/2018	PULLER ASSEMBLY	NTS

COPYRIGHT © 2011 BY DART AEROSPACE LTD
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
 NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT
 THE WRITTEN PERMISSION FROM DART AEROSPACE LTD

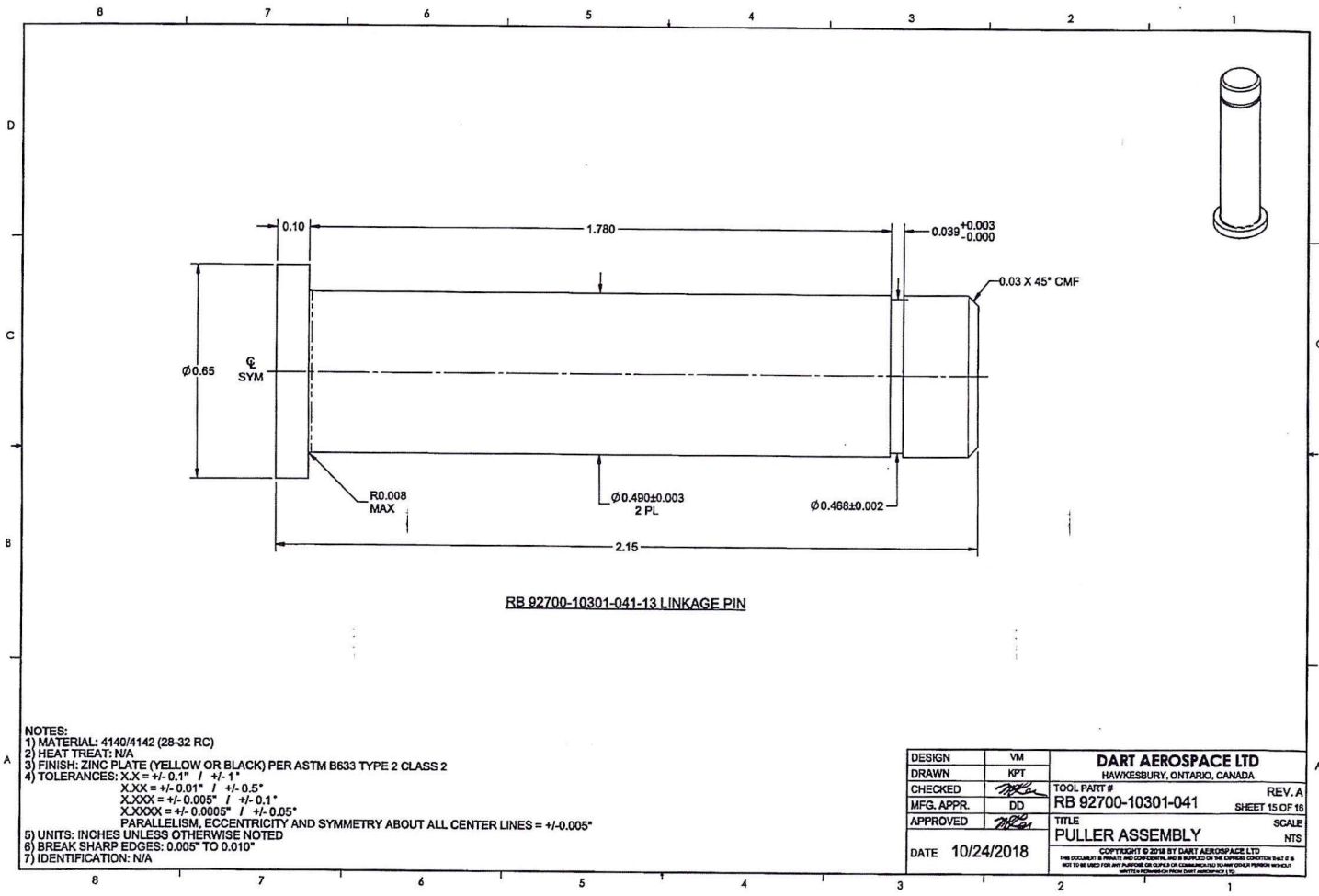


RB 92700-10301-041-12 RIGHT HAND LINKAGE PIN

- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81308 TYPE III OR MIL-C-23411A OR MIL-PRF-81308 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = ± 0.1 / ± 0.1
 X.XX = ± 0.01 / ± 0.5
 X.XXX = ± 0.005 / ± 0.1
 X.XXXX = ± 0.0005 / ± 0.05
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

DESIGN	YM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>Mex</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 14 OF 18
APPROVED	<i>Mex</i>	TITLE	SCALE
DATE	10/24/2018	PULLER ASSEMBLY	NTS

Copyright © 2018 by DART Aerospace Ltd
 All rights reserved. No part of this document may be reproduced or transmitted in any form or by any means electronic or mechanical, including photocopying and recording, or by any information storage or retrieval system, without permission in writing from DART Aerospace Ltd.

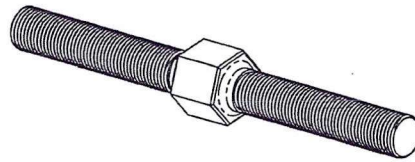


NOTES:

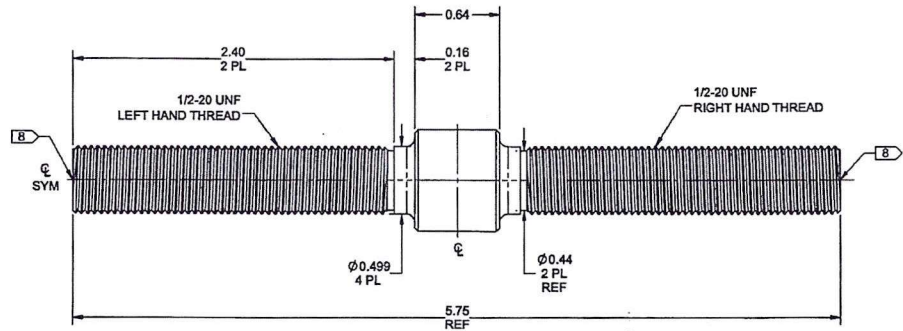
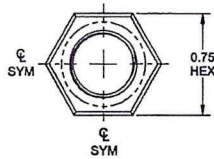
- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = $\pm 0.1^{\circ}$ / $\pm 0.1^{\circ}$
 X.XX = $\pm 0.01^{\circ}$ / $\pm 0.05^{\circ}$
 X.XXX = $\pm 0.005^{\circ}$ / $\pm 0.1^{\circ}$
 X.XXXX = $\pm 0.0005^{\circ}$ / $\pm 0.05^{\circ}$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005^{\circ}$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 15 OF 16
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	10/24/2018	PULLER ASSEMBLY	NTS

COPYRIGHT © 2018 BY DART AEROSPACE LTD
 THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS TO BE KEPT IN THE STRICTEST CONFIDENTIALITY AND IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.



RB 92700-10301-041-14 LINKAGE SCREW



NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: $X.X = \pm 0.1"$ / $\pm 1"$
 $X.XX = \pm 0.01"$ / $\pm 0.5"$
 $X.XXX = \pm 0.005"$ / $\pm 0.1"$
 $X.XXXX = \pm 0.0005"$ / $\pm 0.05"$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 16 OF 18
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	10/24/2018	PULLER ASSEMBLY	NTS

COPYRIGHT © 2018 BY DART AEROSPACE LTD
 THIS DOCUMENT IS UNCLASSIFIED AND CONTROLLED UNDER THE CANADIAN PATENT ACT AND IS NOT TO BE RELEASED FOR ANY PURPOSES OR COPIES OR TRANSMISSIONS TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

PURCHASE ORDER **PO041341**

Tel (613) 632-5200

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO041341
PO Date: 10/12/18
Due Date: 12/21/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Belanger, Natasha
Phone:
Pytm Terms: Net 30
Freight Terms:
Special Comments:

Ship To:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
11	185622	RB 92700- 10301- 041P			Pitch Beam Puller REV A	Firmed	-	12/21/18	1 Ea	0 Ea	1 Ea	\$1,500.00/Ea	\$1,500.00
Line Item Note: SIOP													
16	185663	RB 92700- 10334- 042P			Engine Lifting Sling REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$0.01/Ea	\$0.03
Line Item Note: SIOP													
49	187974	RB 92700- 10301- 041P			Pitch Beam Puller	Firmed	-	12/21/18	2 Ea	0 Ea	2 Ea	\$0.01/Ea	\$0.02
												Grand Total: \$1,500.05	

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/28/18 2:04 PM dart.tsimiklis.chrisoula



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 386

Date: 1/15/19 ✓
PO Ref: 041341 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty
2 ✓

Item
PITCH BEAM PULLER

Part No.
RB 92700-10301-041 ✓

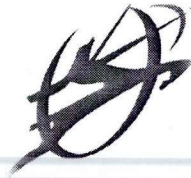
Doc
38
9-89

Received by:

Packaged by: J.M.L.

Checked by: P.S.

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 041341 Dated: 1/15/19

Our Order / Job No: 041341-11AWT2 Order Qty: 2

Part Name: PITCH BEAM PULLER

Part Number: RB 92700-10301-041

Lot Size: N/A Ship Date: 1/15/19

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RB 92700-10301-041 Rev: A

Material Size and Type: -1, -2, -4, -8, -9, -10/4140 STEEL; -3, -6, -7, -11, -12, -13, -14/4140 Q & T

Material Specifications: STEEL: ASTM A108, ASTM A29

Heat Treatment: -1, -2, -4, -8, -9, -10 @ 31 HRC

Plating/Finish: Black Oxide: QMSI-6.2.2 B.O. REV D; Zinc Plate Yellow: ASTM B633 TYPE 2 CLASS 2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 01/15/19

Signed: 

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com

DAS
38
9-89